

Date: Monday, 16/03/2009 2:01:34 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MAINTENANCE STEP, LH
Job Number	: 46524		
Estimate Number	: 11283		
P.O. Number	:	Part Number	: D3436043
This Issue	: 16/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3436 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 42287	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 06/04/2009
Checked & Approved By	: <u>JUD 09.03.16</u>	Qty:	4 Um: Each
Comment	: Est .A 05.05.11 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34361

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Pick:

Qty	Part Number	Description	Batch
1	D3436-1	Clamp	<u>74785</u>

2

EZ 9-3-30 x 4

2.0

D34363

Left Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

LH Step

Pick:

Qty	Part Number	Description	Batch
1	D3436-3	LH Step	<u>B44851</u>

EZ 9-3-30 x 4

3.0

D34365

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3436-5	Bushing	<u>23357</u>

8

EZ 9-3-30 x 4

4.0

D34367

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Pick:

Qty	Part Number	Description	Batch
1	D3436-7	Cap	<u>42323</u>

2

EZ 9-3-30 x 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 2:01:34 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAINTENANCE STEP, LH

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Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/R/N/A	4130	Welding Rod	<u>M10005</u>

Weld left step D3436-7 using welding Jig DT8773 and Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/R/N/A	4130	Welding Rod	<u>M100075</u>

Weld cap D3436-7 as per Dwg D3436 Dwg Rev: A

Qty	Part Number	Description	Batch
A/R/N/A	4130	Welding Rod	<u>M100075</u>

12 9-3-30 (X4)

6.0

BAND SAW

BAND SAW



Comment: BAND SAW

- 1- Slit part D3436-041 on bandsaw as per Dwg D3436
- 2- deburr

EC
BE 9-3-30 (X4)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 9-3-30 (X4)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/30 (X4 LH)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4 - m11013

F2 09/04/14 (4)

START TIME: 10:05
OVEN TEMPERATURE: 400°
FINISH TIME: 10:35

F2 09/04/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/03/2009 2:01:34 PM
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Drawing Name: MAINTENANCE STEP, LH

Job Number: 46524

Part Number: D3436043

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-20

(4)

11.0

D34369

Pad



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pad

Install pad using contact cement as per manufacturer's instructions and Dwg D3436

Dwg Rev: A

Pick:

Qty Part Number Description Batch

2 D3436-9 Pad

A/R N/A Contact Cement

B42414 (2)

34659312

1109109

09/04/21 (4)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5076421 (4 LH)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 203

9/4/21

50

(4)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22

Job Completion



MF
09-04-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

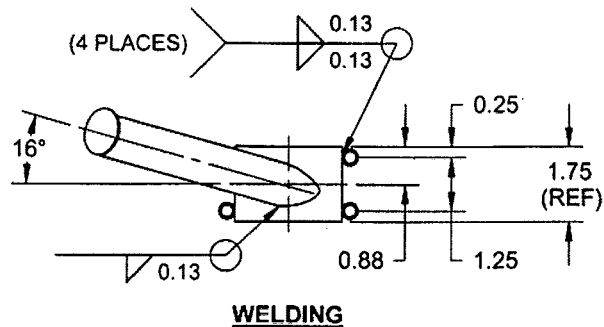
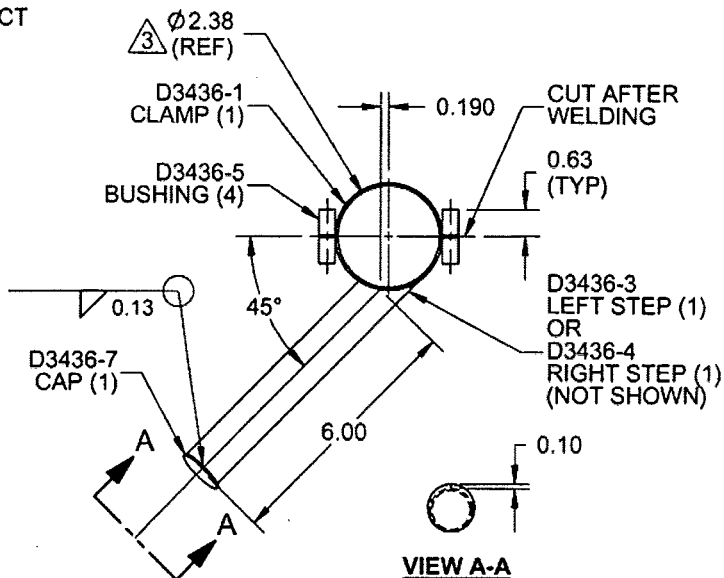
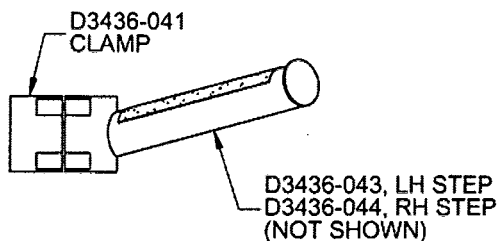
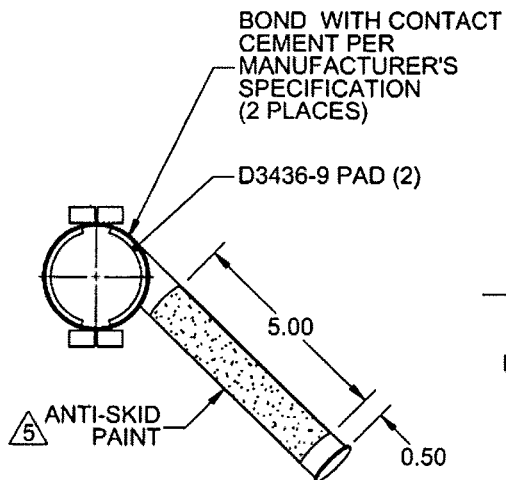
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED //	APPROVED //	DRAWING NO. D3436
DATE 05.04.28	TITLE MAINTENANCE STEP	REV. A SHEET 1 OF 4
A	05.04.28	NEW ISSUE



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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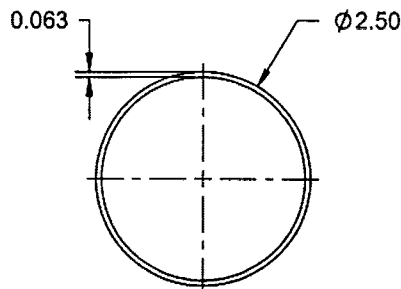
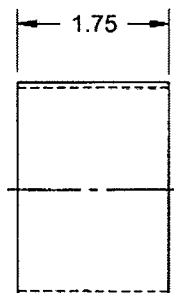
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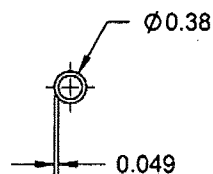
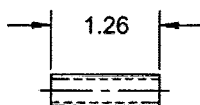


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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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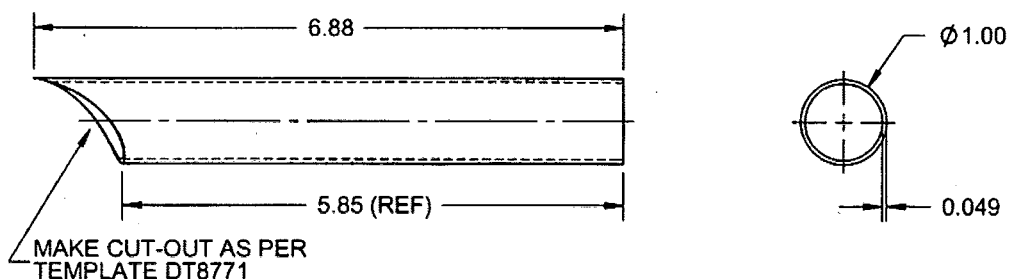
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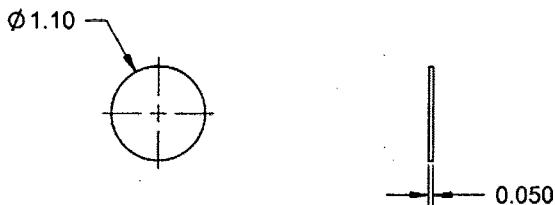
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DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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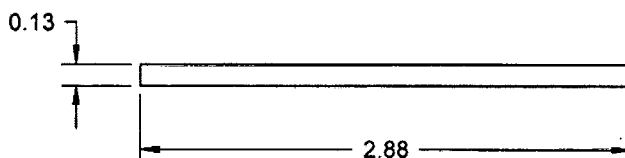
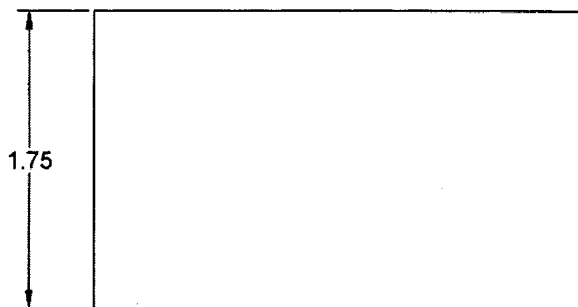
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DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



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05.05.27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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